

MATERIAL	Hardness: ≤ 28 Rc (≤ 271 HBn)											
	SFM	Chip Load (IPT) By Cutter Diameter								Depth of Cut		
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Radial	Axial
ALUMINUM ALLOYS												
Casting (2xx, 5xx, 7xx, 8xx)	1250	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1500											
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	950											
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	900											
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	850	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700											
Wrought - 5%-8% Si (4xxx)	1500											
Wrought - 8%-12% Si (4xxx)	1000											
MAGNESIUM ALLOYS	1500	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK
ZINC ALLOYS	1000											
COPPER ALLOYS												
High Coppers - 90%+ (C1xxxx)	500											
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	700											
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	500											
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	700											
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	700	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	500											
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	750											
PLASTICS Unfilled & Filled	1500	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK
COMPOSITES	800	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	.00150	5x THK	Full THK



Speeds & Feeds

Product Table: Slitting Saws - For Non-Ferrous Materials

Series: SNAxxxx, SNBxxxx, SNCxxxx, SNDxxxx, SNExxxx, SNFxxxx, SNGxxxx

Product notes:

When Thickness to Cutter Diameter ratio is less than 1%, reduce IPT to 50% and Radial Depth of cut to 3x Thickness

For greater Radial Depth of cuts:
8x Thickness, reduce SFM by 10%
10x Thickness, reduce SFM by 20%

General notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. Chip loads reflect uncoated cutters and may be increased up to 15% if coated.

If you require additional information, Harvey Tool has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **800-645-5609** or Harveytech@harveyperformance.com.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.